

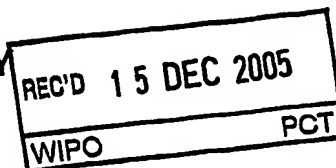
PATENT COOPERATION TREATY


PCT

INTERNATIONAL PRELIMINARY REPORT ON PATENTABILITY

(Chapter II of the Patent Cooperation Treaty)

(PCT Article 36 and Rule 70)



Applicant's or agent's file reference P4/05/2005		FOR FURTHER ACTION		See Form PCT/PEAA16
International application No. PCT/PL2004/000092		International filing date (day/month/year) 19.11.2004		Priority date (day/month/year) 20.11.2003
International Patent Classification (IPC) or national classification and IPC B65D1/02, B29C49/00				
Applicant INVENTO SPOLKA Z O.O.				
<p>1. This report is the international preliminary examination report, established by this International Preliminary Examining Authority under Article 35 and transmitted to the applicant according to Article 36.</p> <p>2. This REPORT consists of a total of 7 sheets, including this cover sheet.</p> <p>3. This report is also accompanied by ANNEXES, comprising:</p> <p>a. <input checked="" type="checkbox"/> sent to the applicant and to the International Bureau) a total of 5 sheets, as follows:</p> <p><input type="checkbox"/> sheets of the description, claims and/or drawings which have been amended and are the basis of this report and/or sheets containing rectifications authorized by this Authority (see Rule 70.16 and Section 607 of the Administrative Instructions).</p> <p><input checked="" type="checkbox"/> sheets which supersede earlier sheets, but which this Authority considers contain an amendment that goes beyond the disclosure in the international application as filed, as indicated in item 4 of Box No. I and the Supplemental Box.</p> <p>b. <input type="checkbox"/> (sent to the International Bureau only) a total of (indicate type and number of electronic carrier(s)) , containing a sequence listing and/or tables related thereto, in computer readable form only, as indicated in the Supplemental Box Relating to Sequence Listing (see Section 802 of the Administrative Instructions).</p>				
<p>4. This report contains indications relating to the following items:</p> <p><input checked="" type="checkbox"/> Box No. I Basis of the opinion</p> <p><input type="checkbox"/> Box No. II Priority</p> <p><input type="checkbox"/> Box No. III Non-establishment of opinion with regard to novelty, inventive step and industrial applicability</p> <p><input type="checkbox"/> Box No. IV Lack of unity of invention</p> <p><input checked="" type="checkbox"/> Box No. V Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement</p> <p><input type="checkbox"/> Box No. VI Certain documents cited</p> <p><input checked="" type="checkbox"/> Box No. VII Certain defects in the international application</p> <p><input checked="" type="checkbox"/> Box No. VIII Certain observations on the international application</p>				
Date of submission of the demand 20.06.2005		Date of completion of this report 14.12.2005		
Name and mailing address of the International preliminary examining authority:  European Patent Office D-80298 Munich Tel. +49 89 2399 - 0 Tx: 523656 epmu d Fax: +49 89 2399 - 4465		Authorized Officer Ingelgard, T. Telephone No. +49 89 2399-7249		



**INTERNATIONAL PRELIMINARY REPORT
ON PATENTABILITY**

International application No.
PCT/PL2004/000092

Box No. I Basis of the report

1. With regard to the **language**, this report is based on the international application in the language in which it was filed, unless otherwise indicated under this item.
- ☐ This report is based on translations from the original language into the following language , which is the language of a translation furnished for the purposes of:
- ☐ international search (under Rules 12.3 and 23.1(b))
 - ☐ publication of the international application (under Rule 12.4)
 - ☐ international preliminary examination (under Rules 55.2 and/or 55.3)
2. With regard to the **elements*** of the international application, this report is based on *(replacement sheets which have been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this report as "originally filed" and are not annexed to this report):*

Description, Pages

1-4 received on 20.06.2005 with letter of 20.06.2005

Claims, Numbers

1-5 received on 20.06.2005 with letter of 20.06.2005

Drawings, Sheets

1/2, 2/2 as originally filed

- ☐ a sequence listing and/or any related table(s) - see Supplemental Box Relating to Sequence Listing
3. ☐ The amendments have resulted in the cancellation of:
- ☐ the description, pages
 - ☐ the claims, Nos.
 - ☐ the drawings, sheets/figs
 - ☐ the sequence listing (*specify*):
 - ☐ any table(s) related to sequence listing (*specify*):
4. ☒ This report has been established as if (some of) the amendments annexed to this report and listed below had not been made, since they have been considered to go beyond the disclosure as filed, as indicated in the Supplemental Box (Rule 70.2(c)).
- ☒ the description, pages 1-4
 - ☒ the claims, Nos. 1-5
 - ☐ the drawings, sheets/figs
 - ☐ the sequence listing (*specify*):
 - ☐ any table(s) related to sequence listing (*specify*):

* If item 4 applies, some or all of these sheets may be marked "superseded."

**INTERNATIONAL PRELIMINARY REPORT
ON PATENTABILITY**

International application No.
PCT/PL2004/000092

Box No. V Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

1. Statement

Novelty (N)	Yes: Claims	3, 6-8
	No: Claims	1,2,4,5,9
Inventive step (IS)	Yes: Claims	
	No: Claims	1-9
Industrial applicability (IA)	Yes: Claims	1-9
	No: Claims	

2. Citations and explanations (Rule 70.7):

see separate sheet

Box No. VII Certain defects in the international application

The following defects in the form or contents of the international application have been noted:

see separate sheet

Box No. VIII Certain observations on the international application

The following observations on the clarity of the claims, description, and drawings or on the question whether the claims are fully supported by the description, are made:

see separate sheet

**INTERNATIONAL PRELIMINARY
REPORT ON PATENTABILITY
(SEPARATE SHEET)**

International application No.

PCT/PL2004/000092

Re Item I.

This preliminary examination report is based on the originally filed application. The amendments of 20.06.2005 (new claims 1-5, deleting old 6-9 and new description, pages 1-4) are considered to go beyond the disclosure of the international application as filed (Article 34(2)(b) PCT):

Deficiencies (features that go beyond the originally filed disclosure):

Claim 1, filed 20.06.2005:

- single layer body

Claim 2, filed 20.06.2005:

- the claimed measures

Description, filed 20.06.2005

- from "The summary of the invention" and further on.

If the applicant considers to continue the examination procedure in the national phase, the applicant is recommended to base his amendments on the application as originally filed at the ISA on 19.11.2004. Special care should be taken not to add any new subject matter not already disclosed in the original application. See also paragraph 5.5 below.

Re Item V.

5.1 Reference is made to the following documents:

D1: US-A-4 751 035 (MCHENRY ET AL) 14 June 1988 (1988-06-14)

D2: WO 83/01766 A (THE CONTINENTAL GROUP, INC) 26 May 1983 (1983-05-26)

D3: EP-A-0 482 652 (NISSEI ASB MACHINE CO., LTD) 29 April 1992 (1992-04-29)

D4: EP-A-0 978 456 (A.K. TECHNICAL LABORATORY, INC) 9 February 2000 (2000-02-09)

D5: US-A-5 833 085 (VALYI ET AL) 10 November 1998 (1998-11-10)

INDEPENDENT CLAIM 1

5.2 The present application does not meet the criteria of Article 33(1) PCT, because the subject-matter of claim 1 is not new in the sense of Article 33(2) PCT.

Document D1 discloses (the references in parentheses applying to this document):

A preform of a plastic container designed for packaging foodstuffs (figure 1A), comprising a container body with a convex hemispherical bottom (38), wherein the body has a conical shape (11) that opens upwards and ends with a cylindrical neck (12) surrounded by a flange terminated in a rim* (13).

It is noted that also document D2 contains all features of claim 1.

* From figures 2-5, in particular figure 5, of the present application it's clear that any kind of ending of a flange is called a rim.

DEPENDENT CLAIMS 2, 4, 5, 9

5.3 Dependent claims 2, 4*, 5 and 9 do not contain any features which, in combination with the features of any claim to which they refer, meet the requirements of the PCT in respect of novelty (Article 33(2) and (3) PCT), see document D1, figure 1A.

* To manufacture a preform without radiuses (arced transition surfaces) is impossible, therefore the arched transition is implicitly contained in document D1.

DEPENDENT CLAIMS 3, 6-8

5.4 The present application does not meet the criteria of Article 33(1) PCT, because the subject-matter of claims 3, 6-8 does involve an inventive step in the sense of Article 33(3) PCT. See also paragraph 5.5 below.

Document D1 which is considered to represent the most relevant state of the art, discloses a preform from which the subject-matter of claims 3, 6-8 differs in that:

- the flange has a thickness of 0.3mm, and
- the rim of the flange has annular thickenings (on top and/or underneath) whose height

varies from 1.1 to 2.0 times the flange thickness.

The technical effect of these features are that:

- the flange is soft enough to adapt to the lid to be sealed to the flange, and
- the flange is strong enough for providing a quality connection between the lid and the container.

The problem to be solved by the present invention may therefore be regarded as:

- how to design a lid that is soft enough to adapt to the lid, and
- how to design a flange that is strong enough for providing a quality connection between the lid and the container

5.4.1 Claim 3: The thickness 0.3mm that provides a soft flange seems to be a normal thickness of a flange that is to be sealed by a lid, see document D3, claim 4.

5.4.2 Claims 6-8: The use of thickenings around the flange of preforms to be sealed with a lid seems to be one of several straightforward possibilities to reinforce the flange, without the exercise of inventive skill, in order to solve the problem posed (see document D4, figure 3, paragraphs 24-28, 35, figure 3; document D5, figure 2). No unexpected advantage can be seen with the range 1.1-2.0 proposed by the claims. The thicker the thickening around the flange, the stronger the flange. The range also seems too broad to give any unique advantage.

5.5 For claims 6-8 the examining division would have re-considered the possibility of inventiveness if the applicant had presented convincing arguments using the "problem solution approach", showing why the claimed features are inventive. See also paragraph 7.4 below.

Re Item VII.

7.1 The reference signs used in the claims and in the description are underlined. Preferably the underlining is removed (Rule 6.2(b) PCT).

7.2 Independent claim 1 is not in the two-part form in accordance with Rule 6.3(b) PCT,

which in the present case would have been appropriate, with those features known in combination from the prior art (document D1) being placed in the preamble (Rule 6.3(b)(I) PCT) and with the remaining features being included in the characterising part (Rule 6.3(b)(ii) PCT).

7.3 Contrary to the requirements of Rule 5.1(a)(ii) PCT, the relevant background art disclosed in the document D1 is not mentioned in the description, nor is this document identified therein.

7.4 From the description it is not fully clear which the problems of the state of the art preforms are and which features are added to the preform according to the invention of the present application and how these features solves the problems of the state of the art (Rule 5 PCT). See also paragraph 5.5 above.

Re Item VIII.

8 The application does not meet the requirements of Article 6 PCT, because in claim 3 it is not mentioned where the two wall thicknesses are to be measured, thereby rendering the definition of the subject-matter of said claim unclear, Article 6 PCT.

DESCRIPTION AMENDED UNDER ART. 34**A preform of a plastic container particularly for packaging foodstuffs****The field of the invention**

This invention relates to the preform of a plastic container particularly for packaging foodstuffs. This preform is formed using the conventional injection moulding machinery and utilised to form plastic containers, such as cans, for packaging foodstuffs, and especially to blow mould thin-walled containers which can be hermetically closed with a metal lid secured to the container by seaming the lid flange on filling machines, without deforming the flange or the cylindrical neck under it.

The state of art

The Polish patent application no. P 336 680 A1 relates to a plastic preform designed for forming thin-walled containers. The preform has a threaded neck and a cylindrical body terminated with a convex hemispherical bottom. The body diameter of this preform is 0.5 to 0.85, and the body wall thickness is 0.08 to 0.18, of the neck diameter.

It has been known for some time how to form thin-walled containers terminated with a flange by blow moulding the conventional preform and then severing the top portion of the container including a threaded neck. In this way immense amounts of scrap are produced, which the result that the whole process is highly uneconomical. Furthermore, this method leaves much uncertainty about the reliability of the closure, including its tightness and resistance to pressures inside the container. The edge of the container flange may become nicked by cutting operations and its thickness may vary along the circumference, which is normal as the flange is blow moulded as a part of the side wall of a larger container.

In order for the closure of the plastic container to be tight under pressure, it would be best if the container was formed by a stretch blow moulding process from the injection moulded preform. Patent EP 0482652B1 describes a cylindrical preform with a flat bottom, wherein the bottom is much thinner than the preform walls that gradually slightly part. Due to the fact that the flow of material is hindered, it is impossible to achieve the flange thickness that is below 0.3 mm. The preform flange is smooth and does not have a thickened rim.

Patent WO-A 83/01766 presents a preform, which is generally cylindrical in shape and slightly tapers in the downward direction; its walls and bottom have the same thickness. The flange is smooth and does not have a thickened rim. It has been noted in the document that it is impossible for one to achieve a good degree of material orientation in the flange of such preform; hence, its strength is insufficient for good quality connection between the metal lid and the container.

The document US 4 751 035 A presents a multi-layer preform where the transition between the

conical and cylindrical parts takes the form of a step down, while the flange is relatively thick (0.6 mm). The above-mentioned multi-layer preform solves the problem of multi-layer injection, while it fails to achieve the required optimal flange parameters. It is evident that neither the neck nor the flange are affected by the blow moulding process and that they should emulate the neck and flange shape of a metal can as closely as practicable, in order to enable closing using a typical metal lid. This problem was solved by the invention presented herein, which allows one to obtain a thin, elastic and strong flange by the injection of the moulding of the preform, that is suitable for double seaming of a metal lid using typical closing machines. The route along which the plastic material flows during the injection moulding of the preform performs a decisive impact on the mechanical properties of the flange. A thickened rim on the preform flange also plays an important role. Not only does it improve the hermetic connection between the metal lid and the flange but it also prevents the thin flange from slipping out of the lock.

The summary of the invention

A preform of a plastic container designed particularly for packaging foodstuffs comprising a conically-shaped container body with a convex hemispherical bottom, which flares towards a cylindrical neck, characterised by the single-layer body in which the external diameter of the cone as measured at the point of connection with the cylindrical part is equal to the external diameter of the cylindrical part, where the cylindrical part ends with a flange terminated in a thickened rim). The opening angle of the internal conical surface of the body is greater than the opening angle of the external conical surface of the body; hence, the bottom is the thickest part of the container body and the cylindrical neck is significantly thinner than the bottom. The inflow of the material to the neck space and then to the flange is easy. This is due to the fact that the bottom at the injection point is relatively thick, the walls are appropriately inclined and their thickness tapers in a favourable manner. The material flow velocity in the mould is relatively high during the forming process with the result that the time taken by the material to reach the preform peripheries, including the flange, is short and a decline in temperature of the flowing material is much lower, which allows for appropriate filling and orientation and ensures a far better flange strength. In this way, it is possible for the flange thickness to be less than 0.25 mm, which is required for good quality seaming of the metal lid. The flange has a good degree of material orientation, is elastic and strong. The best seaming quality is achieved when there is a gradual change in thickness between the cylindrical neck and the flange and the transition between these two elements is arched. Preferably, the ratio of the flange thickness to the cylindrical neck thickness should be approximately 0.8.

Furthermore, in order to ensure that the container metal lid fits precisely into the flange rim, it is desirable that the angle between the flange and the cylindrical neck is $180^\circ - \gamma$, where γ lies within a range of 60° to 90° , and most preferably equals 78° .

In order for the seaming operation to ensure a good quality connection between the pressure container and the metal lid, the flange should terminate in a thickened annular rim showing on one or both sides of the flange ending. The height of the annular thickened rim should vary from 1.1 to 2.0 of the flange thickness.

The brief description of the drawings

The present invention has been described in greater detail below in its advantageous examples of embodiments with reference to the enclosed drawings. Fig. 1 presents an axial sectional view of the preform. Fig. 2 presents an enlarged picture of the preform flange with a double-sided annular thickened rim. Fig. 3 presents an enlarged picture of the preform flange with a one-sided annular thickened rim on top of the flange. Fig. 4 presents an enlarged picture of the preform flange with a one-sided annular thickened flange rim underneath the flange. Fig. 5 presents an enlarged picture of the preform flange with rectangular flange ending.

The most efficient version

As shown in Fig. 1, the preform 1 of a plastic container particularly for packaging foodstuffs, includes a body 4 with a convex hemispherical bottom 6. The body 4 has a conical shape that opens upwards and ends with a cylindrical neck 2 surrounded by a radially outwardly extended flange 3 terminated in a thickened rim 5. The thickness of the body 4 decreases gradually starting from the bottom 6; therefore, the thickness g_2 of the cylindrical neck 2 as measured at any point along the cylindrical wall is significantly less than the thickness g_3 of the bottom 6. The flange thickness g_1 as measured at a distance of approximately 5 mm from the flange end (preferably app. 0.20 mm) is less than 0.25 mm.

Fig. 2 shows an enlarged rim 5 of the flange 3 of the preform 1 which is deviated from the cylindrical neck at an angle of $180^\circ - \gamma$, where γ lies within a range of 60° to 90° . The flange 3 terminates in an annular thickened rim 5a on both its sides. The height h of the thickened rim 5a varies from 1.1 to 2.0 of the flange thickness g_1 .

Fig. 3 shows an enlarged rim 5 of the flange 3 of the preform 1 which is deviated from the cylindrical neck at an angle of $180^\circ - \gamma$, where γ lies within a range of 60° to 90° . The flange 3 terminates in a one-sided annular thickened rim 5b on the top of it. The height h of the thickened rim 5b varies from 1.1 to 2.0 of the flange thickness g_1 .

Fig. 4 shows an enlarged rim 5 of the flange 3 of the preform 1 which is deviated from the cylindrical neck at an angle of $180^\circ - \gamma$, where γ lies within a range of 60° to 90° . The flange 3

terminates in a one-sided annular thickened rim 5c underneath it. The height h of the thickened rim 5c varies from 1.1 to 2.0 of the flange thickness g1.

Fig. 5 shows an enlarged rim 5 of the flange 3 of the preform 1 which is deviated from the cylindrical neck at an angle of $180^\circ - \gamma$, where γ lies within a range of 60° to 90° . The flange 3 terminates in a rectangular rim 5d whose height h is generally equal to the flange thickness g1.

The preform 1 in the described embodiment has typical external dimensions D1 (max. diameter and H (height) is made of polyethylene terephthalate (PET), a thermoplastic material specifically designed for packaging foodstuffs. When using the subject preform to blow mould a thin-walled container, the diameters D1 and D2 of the cylindrical neck 2 and the flange 3 do not change. A relatively small flange thickness allows for a better fit of the metal lid at the first stage of the double seaming process. The thickening of the flange rim ensures a good closure of the container body at the second stage of the double seaming process and also prevents the thin flange from slipping out of the lock..

Claims

1. A preform of a plastic container designed particularly for packaging foodstuffs comprising a conically-shaped container body with a convex hemispherical bottom, which flares towards a cylindrical neck, characterised by the single-layer body (4) in which the external diameter of the cone as measured at the point of connection with the cylindrical part (2) is equal to the external diameter of the cylindrical part, where the cylindrical part (2) ends with a flange (3) terminated in a thickened rim (5).
2. The preform according to claim 1 is characterised by the fact that the thickness (g1) of the flange (3) as measured at a distance of approximately 0.5 mm from the flange end (3) is less than 0.25 mm (preferably app. 0.20 mm) and that the wall thickness (g1) is less than or equal to the cylindrical neck wall thickness (g2).
3. The preform according to claim (1) is characterised by that the rim (5) of the flange (3) has a annular thickening (5a) on top and underneath it, whose height (h) varies from 1.1 to 2.0 of the flange thickness (g1).
4. The perform according to claim (1) is characterised by that the rim (5) of the flange (3) has a ring-like one-sided thickening (5b) on top of it, whose height (h) varies from 1.1 to 2.0 of the flange thickness (g1).
5. The preform according to claim (1) is characterised by that the rim (5) of the flange (3) has a ring-like one-sided thickening (5c) underneath it, whose height (h) varies from 1.1 to 2.0 of the flange thickness (g1).

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